

Picklist Print

October-21-11 8:03:32 AM

Page 8

Work Order ID: 75348

75348

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,610.000

4

4

AI S4-1032-225

Insert

**

del 11/11/21

Location

Loc Qty

Loc Code

ST282

2610

108696

758

110768

62

118386

860

118966

930

del

AN8C35A

Purchased

No

230

Each

113.0000

1

1

AN8C35A

BOLT

**

del 11/12/21

Location

Loc Qty

Loc Code

FP

77

117511

11

118286

66

FP-A

1

115960

1

ST345

34

117834

34

x1

ST346

1

114442

0

115188

0

115960

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 75348

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Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

113.0000

4

4

AN6C44A

BOLT

**

u 11/12/11

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

111

118387

41

118985

40

119125

30

x4

MS21083C8

Purchased

No

230

Each

92.0000

1

1

MS21083C8

NUT

**

u 11/12/11

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614

50

119309

25

y1

D3631-1

Manufactured

No

230

Each

107.0000

8

8

D3631-1

Washer

**

B 75548 (x8) u 11/12/11

Location

Loc Qty

Loc Code

ST072

107

68062

107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 10

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Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

4

4

***AN960C10I ***

washer

D2745

Manufactured

No

230

Each

165.0000

8

8

D2745

Bushing

**

1119736 (x4) HU 11/12/11

**

1374446 (x8) HU 11/12/11

Location

Loc Qty

Loc Code

FP-A

3

69529

3

ST021

162

71835

162

NAS1149C0832R

Purchased

No

230

Each

345.0000

1

1

NAS1149C0832R

WASHER

**

HU 11/12/11

Location

Loc Qty

Loc Code

FP-B

17

114915

17

ST297

328

114915

328

X1

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Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 11

Work Order ID: 75348

75348

Parent Item: D350-636-016

D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

232.0000

4

4

AN3C6A

BOLT

**

1119744 (x4) 11/12/11

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

231

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

176

MS21043-6

Purchased

No

230

Each

505.0000

4

4

MS21043-6

NUT

**

11/12/11

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

485

112314

275

117887

10

118384

200

D3493-1

Manufactured

No

250

Each

55.0000

2

D3493-1

Washer

**

11/12/11 76237

Location

Loc Qty

Loc Code

ST062

55

70697

17

71846

38

October-21-11 8:03:33 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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October-21-11 8:03:33 AM

Page 12

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Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

92.0000

2

2

MS21083C8

NUT

**

11/12/11

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614

50

119309

25

XZ

AN8C21A

Purchased

No

250

Each

69.0000

2

2

AN8C21A

BOLT

**

11/12/11

Location

Loc Qty

Loc Code

ST343

69

118045

19

118758

50

XZ

D2741

Manufactured

No

250

Each

19.0000

1

1

D2741

Blade, 350 Skidtube

**

Location

Loc Qty

Loc Code

ST466

19

70667

19

71856

1 m-f 11/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

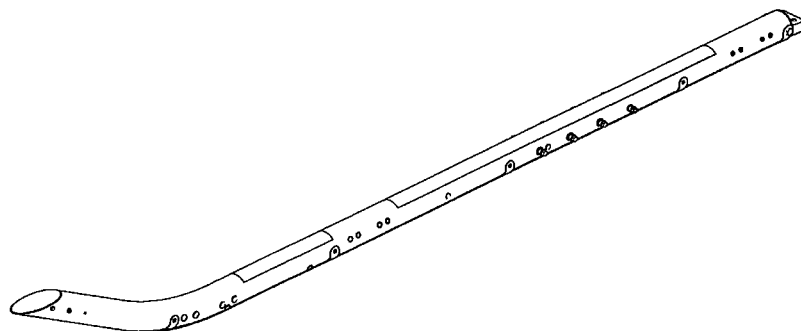
GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

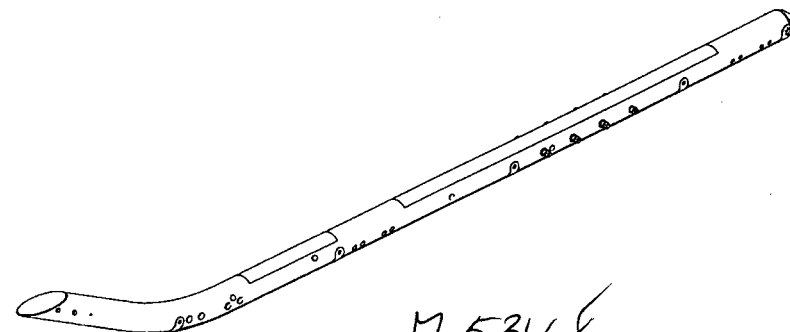
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75348

RELEASED
2010-09-15

A NEW ISSUE		SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



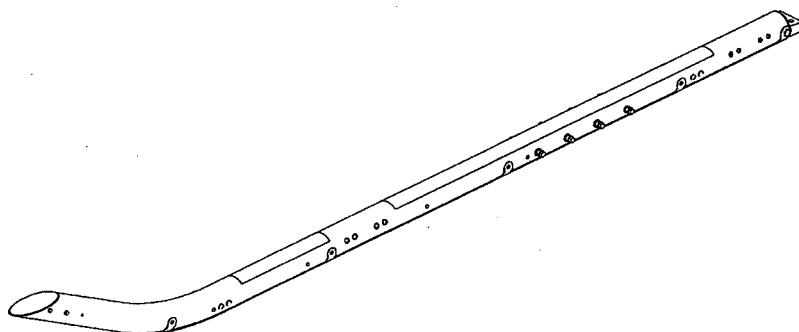
D4168-041 350 SKIDTUBE ASSEMBLY, LH



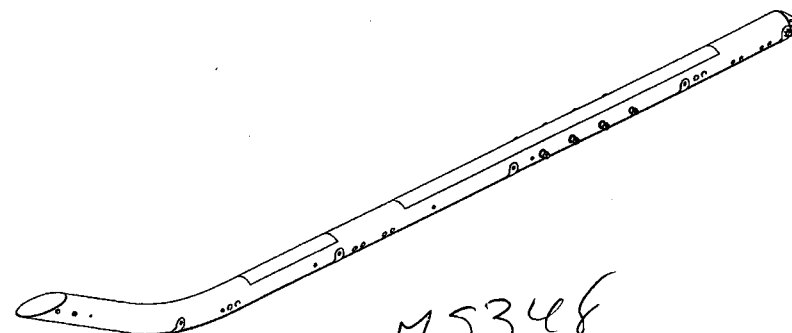
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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2010-09-15
JM

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JF	DRAWING NO. D4168	REV. A
MFG. APPR.	JF	SHEET 2 OF 11	
APPROVED	JF	TITLE	SCALE
DE APPR.	JF	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4168-043 350 SKIDTUBE ASSEMBLY, LH

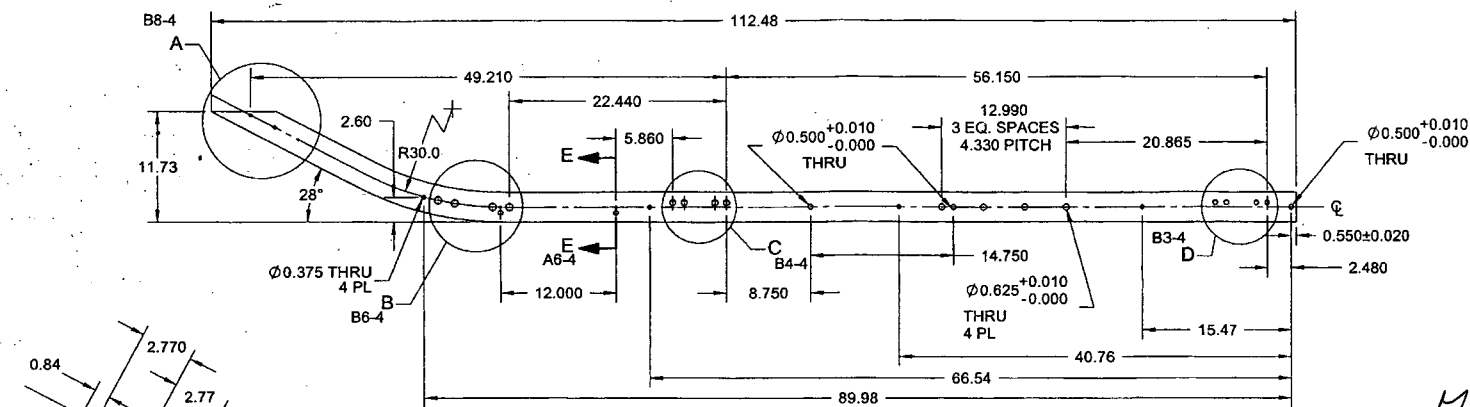


D4168-044 350 SKIDTUBE ASSEMBLY, RH

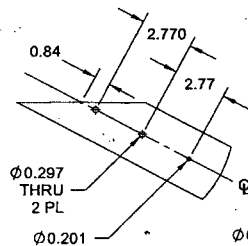
75348

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2010-09-15

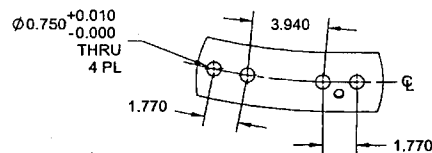
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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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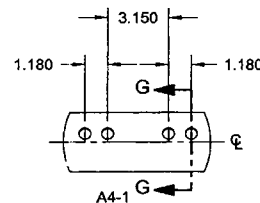
D4168-1 LH SKIDTUBE



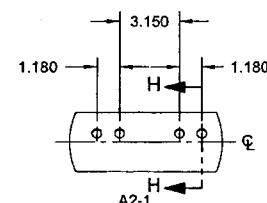
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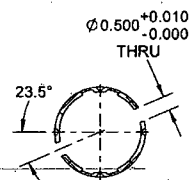
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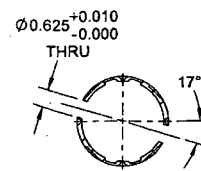
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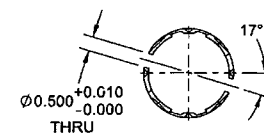
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SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



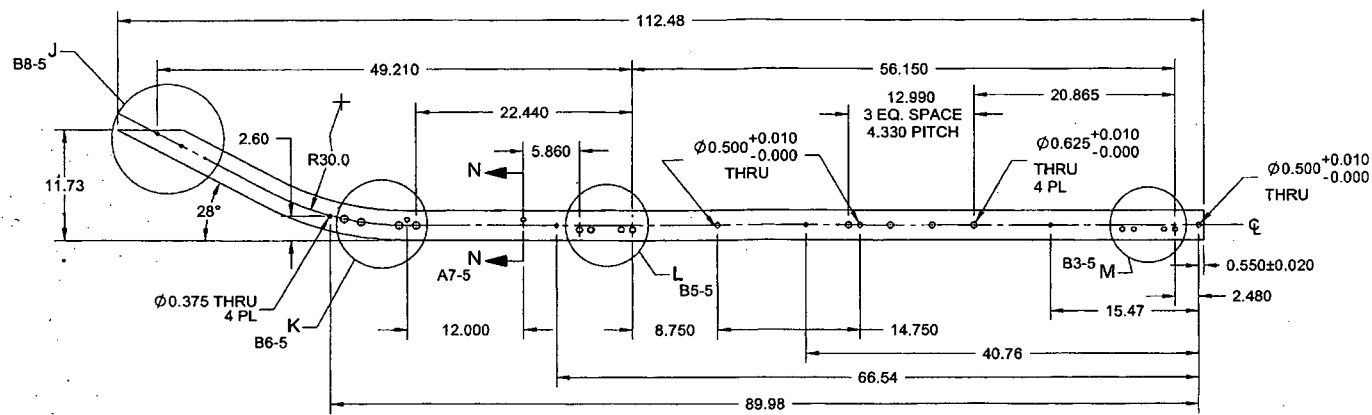
SECTION H-H
SCALE 3X, 4 PL

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2010-09-15

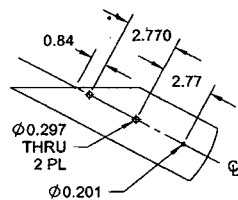
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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO. D4168	REV. A
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	10.08.09	NTS	

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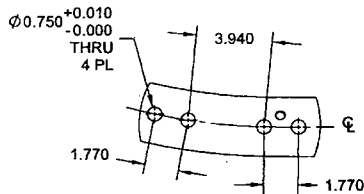
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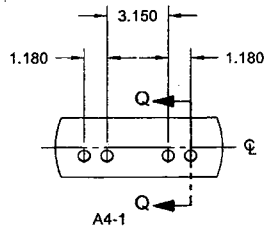
D4168-2 RH SKIDTUBE



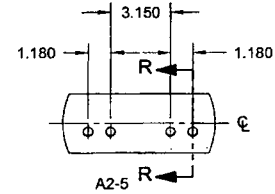
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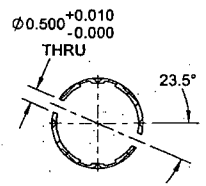
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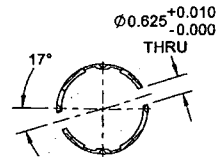
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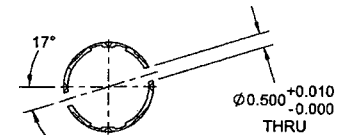
DETAIL M
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SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

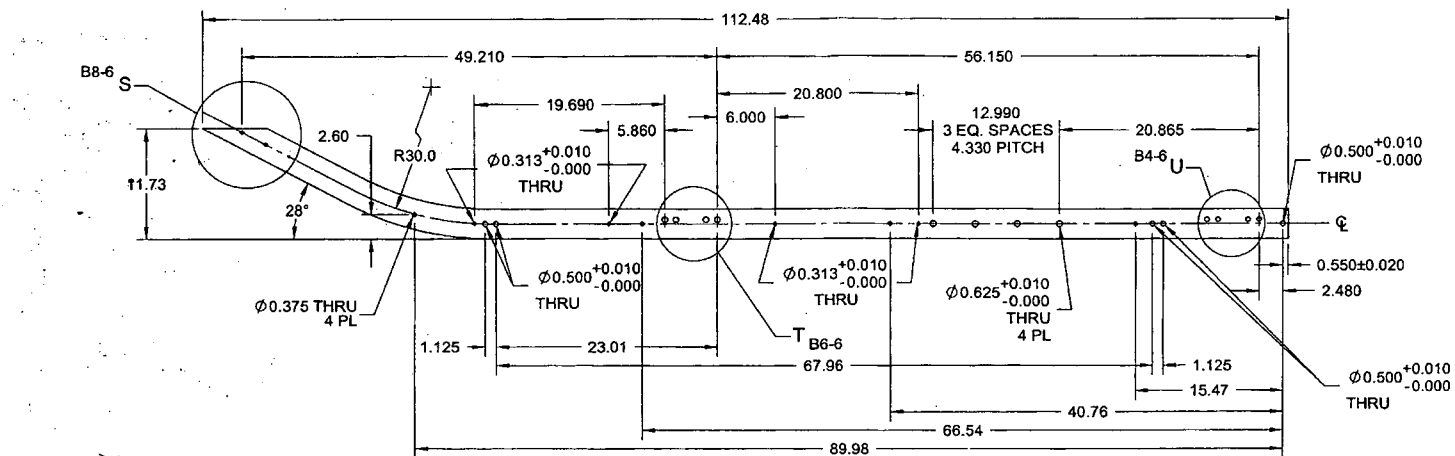
75348

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2010-09-15

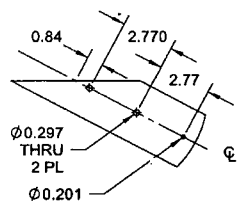
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS.
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8 7 6 5 4 3 2 1

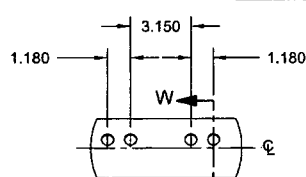
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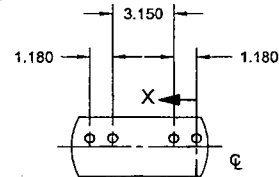
D4168-3 LH SKIDTUBE



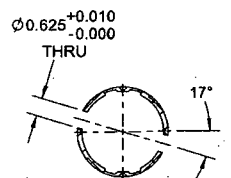
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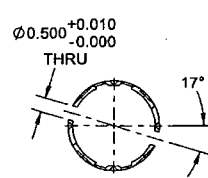
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 6 OF 11
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8 7 6 5 4 3 2 1

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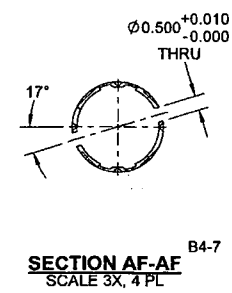
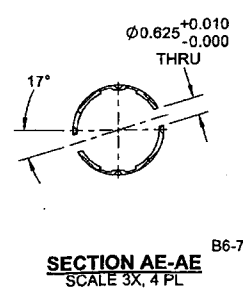
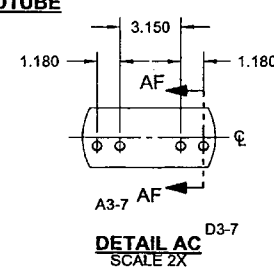
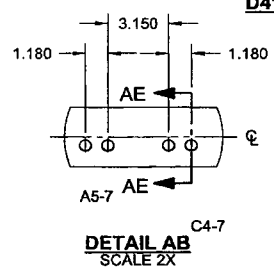
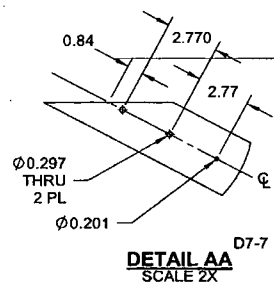
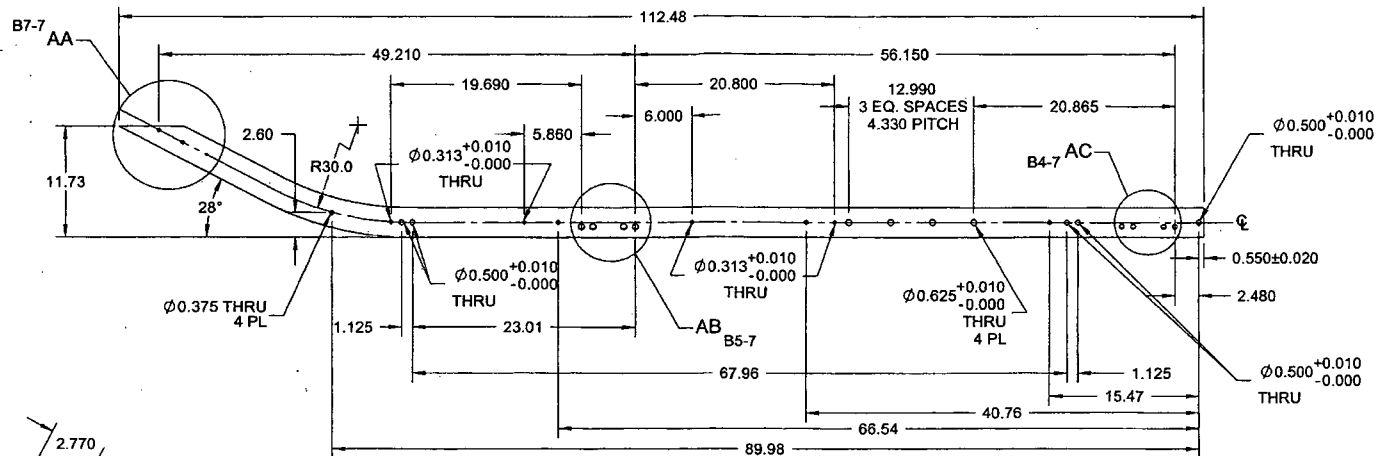
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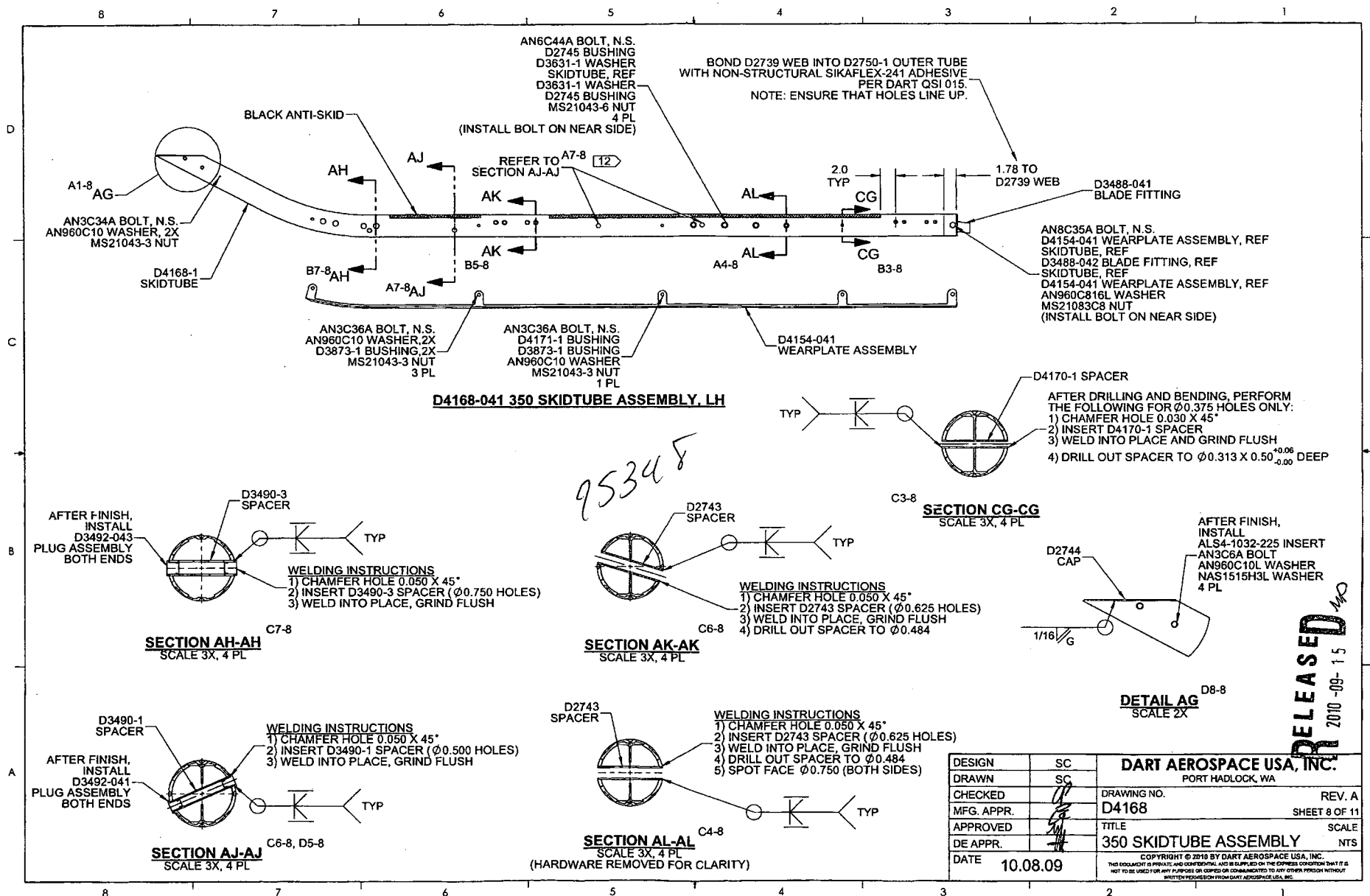


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RELEASED
2010-09-16

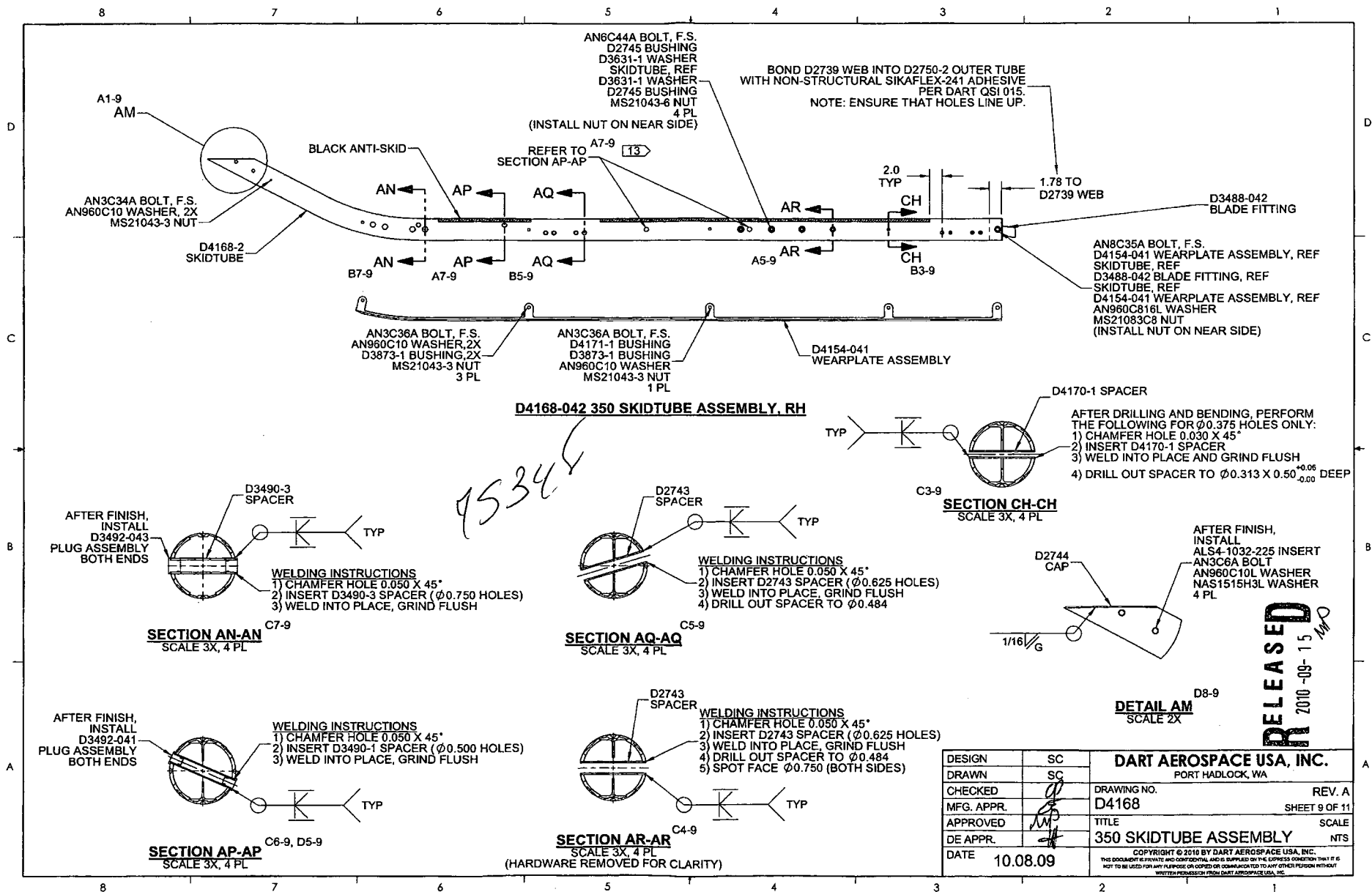
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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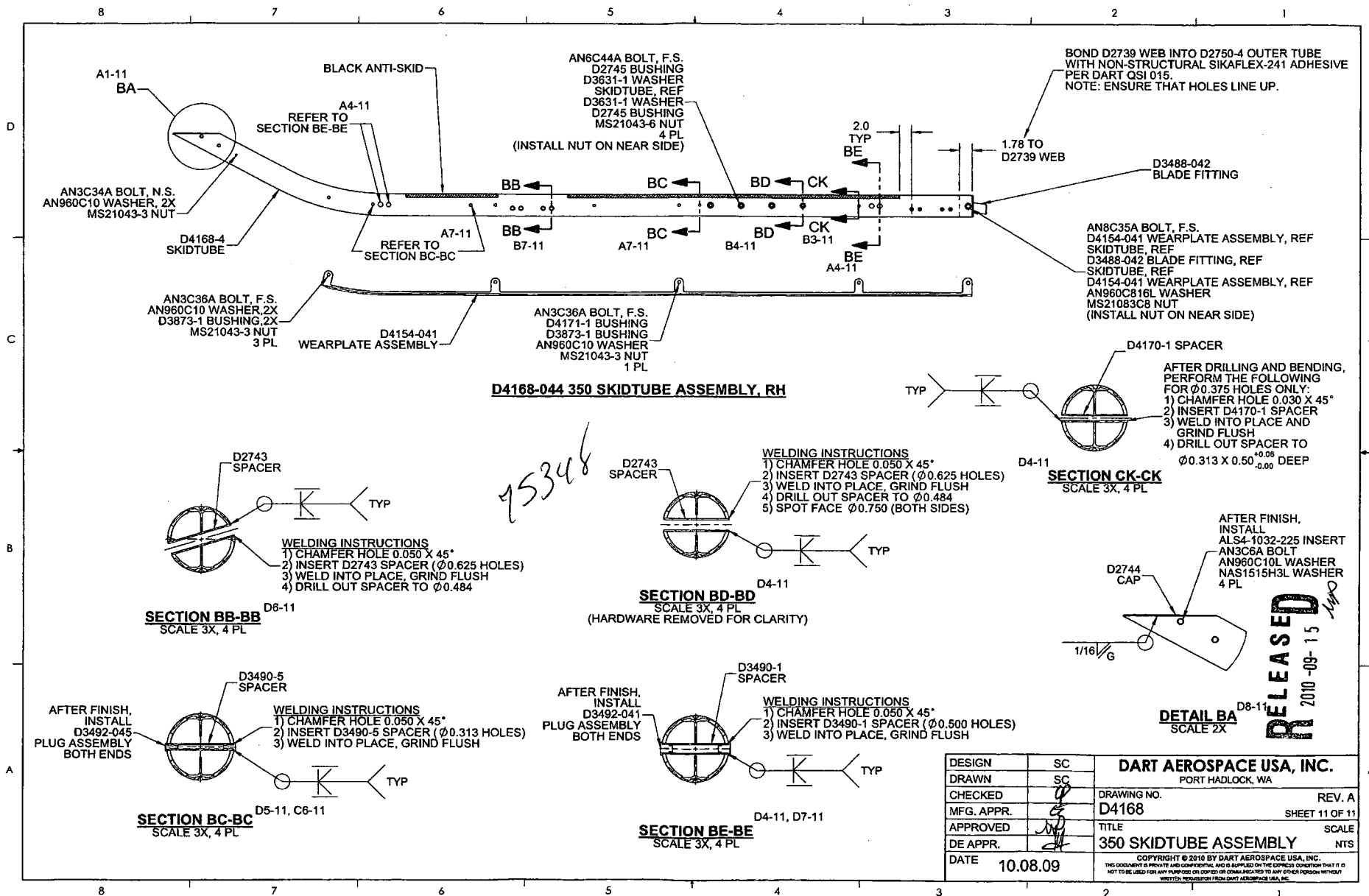


DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4168	SHEET 8 OF 11
APPROVED	SC	TITLE	SCALE
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2010-09-15



RELEASED
2010-09-15



NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 75349
Part number: 350-636-016
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David David Date of Test Coupon 11.11.22
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld